

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013526**Date Inspected:** 06-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

**Tower Trial Assembly**

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW):

Weld joint # 048 located on East Tower Lift-1 outside bearing stiffener Plate ESD1 – SA227F/G. Welder is identified as 040704. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 03A located on West Tower Lift-1 Shear Plate at B/C corner outside WSD1 – A423A/H. Welder is identified as 040723. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U5 – F.

Weld joint # 058 located on South Tower Lift-1 outside bearing stiffener Plate SSD1 – SA16 F/G. Welder is identified as 053116. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

(See attached photo)

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## WELDING INSPECTION REPORT

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Weld joint # 029 located on North Tower Lift-1 inside bearing stiffener Plate NSD1 – SA17F/G. Welder is identified as 054069. ZPMC Quality Control (QC) Inspector is identified as Yang Min Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 03A located on South Tower Lift-1 Shear Plate at B/C corner outside SSD1 – A111A/H. Welder is identified as 053316. ZPMC Quality Control (QC) Inspector is identified as Zhu Yuan Yuan. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U5 – F.

Weld joint # 033 located on East Tower Lift-1 outside bearing stiffener Plate ESD1 – SA227F/G. Welder is identified as 040609. ZPMC Quality Control (QC) Inspector is identified as Fu Wei Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.

Weld joint # 029 located on North Tower Lift-1 inside bearing stiffener Plate NSD1 – SA22B/E. Welder is identified as 040533. ZPMC Quality Control (QC) Inspector is identified as Yang Min Min. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2333 – Tc – P4 – F.  
(See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest - 15000422360, who represents the Office of Structural Materials for your project.

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**Inspected By:** Kumar,Sandeep

Quality Assurance Inspector

**Reviewed By:** Clifford,William

QA Reviewer